

Date: Wednesday, 03/06/2009 10:48:31 AM  
 User: Julie Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: WEB ASSEMBLY		
Job Number	: 48349			Part Number	: D2174041		
Estimate Number	: 10194			Drawing Number	: D2174 REV E		
P.O. Number	:			Project Number	: N/A		
This Issue	: 03/06/2009 S.O. No. :			Drawing Revision	: E		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : SMALL /MED FAB			Due Date	: 20/06/2009 Qty: 52		
Previous Run	: 37741			Um:	Each		
Written By	:						
Checked & Approved By	: <u>STUP 09.06.03</u>						
Comment	: Est: D 04.06.10 Reformat; Changed Step 2 KJ/JLM Est Rev:E As per Rev E 06-11-22 JLM						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	D21741	Web		 <u>E509/06/15</u>
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)		
		Web		
		Qty Part Number Description Batch		
		1 D2174-1 Web <u>B 48412 ⑪</u>		<u>B 37848 ⑩</u>
2.0	D21751	Angle LH		
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)		
		Angle LH		
		Qty Part Number Description Batch		<u>E509/06/15</u>
		1 D2175-1 Angle <u>B 31691</u>		
3.0	D21752	Angle RH		
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)		
		Angle RH		
		Qty Part Number Description Batch		
		1 D2175-2 Angle <u>B 48 413</u>		<u>E509/06/15</u>
4.0	MS20470AD46	Rivet, Universal Head		
		Comment: Qty.: 19.0000 Each(s)/Unit Total : 152.0000 Each(s)		
		Rivet, Universal Head		
		Qty Part Number Description Batch		
		19 MS20470AD4-6 Rivet <u>17110915</u>		<u>E509/06/15</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 03/06/2009 10:48:31 AM  
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Drawing Name: WEB ASSEMBLY

Job Number: 48349

Part Number: D2174041

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per Dwg D2174-041

2- Identify as D2174-041

Ep 09/06/15 (12)

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/06/15 (12)

7.0 POWDER COATING

POWDER COATING



M111472

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 2:18 pm

OVEN TEMPERATURE: 3200F

FINISH TIME: 2:48 pm

JH 09-06-15 (12)

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

Fix 09/06/15

9.0 AN526C832R14

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 32.0000 Each(s)

Screw

Batch:

M1D916

9/6/15

SP

10.0 AN960JD8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 32.0000 Each(s)

Washer

Batch:

M110917

9/6/15

SP

11.0 MS21042L08

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 32.0000 Each(s)

Nut

Batch:

M111889

9/6/15

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

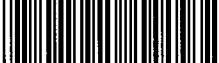
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 03/06/2009 10:48:31 AM  
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## Process Sheet

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Job Number: 48349		Part Number: D2174041
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
12.0	SMALL FAB 1 	SMALL & MEDIUM FAB RESOURCE 1 
<p>Comment: SMALL &amp; MEDIUM FAB RESOURCE 1 Install nuts &amp; bolts loosely as per Dwg D2274</p> <p><i>8/30/06/16 (12)</i></p>		
13.0	QC5 	INSPECT WORK TO CURRENT STEP 
<p>Comment: INSPECT WORK TO CURRENT STEP</p> <p><i>S 09/06/16 (12)</i></p>		
14.0	PACKAGING 1 	PACKAGING RESOURCE #1 
<p>Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <i>100</i> <i>already</i> <i>SL</i></p>		
15.0	QC21 	FINAL INSPECTION/W/O RELEASE 
<p>Comment: FINAL INSPECTION/W/O RELEASE</p> <p><i>09/06/16 (12)</i></p>		
Job Completion 		<i>MF</i> <i>09-06-16</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN RF	DRAWN BY <i>CE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>PH</i>	APPROVED <i>CH</i>	DRAWING NO. D2174	REV. E	SHEET 1 OF 2
DATE 06.09.25		TITLE WEB ASSEMBLY	SCALE 1:3	
A	95.10.25	NEW ISSUE		
B	96.01.18	RE-DRAWN		
C	00.09.11	UPDATE FINISH SPEC.		
D	04.06.03	RE-DESIGN		
E	06.09.25	INC 4 HOLES TO #0.172; CHG HARDWARE		

**RELEASED**

06-10-13-#

QTY -041	P/N	DESCRIPTION
X	D2174-041	WEB ASSEMBLY
1	D2174-1	WEB
1	D2175-2	ANGLE
1	D2175-1	ANGLE
4	AN526C832R14	SCREW
4	AN960JD8	WASHER
4	MS21042L08	NUT
19	MS20470AD4-6	RIVET

**NOTES:**

- 1) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) IDENTIFY WITH P/N D2174-041 USING FIND POINT PERMANENT INK MARKER.

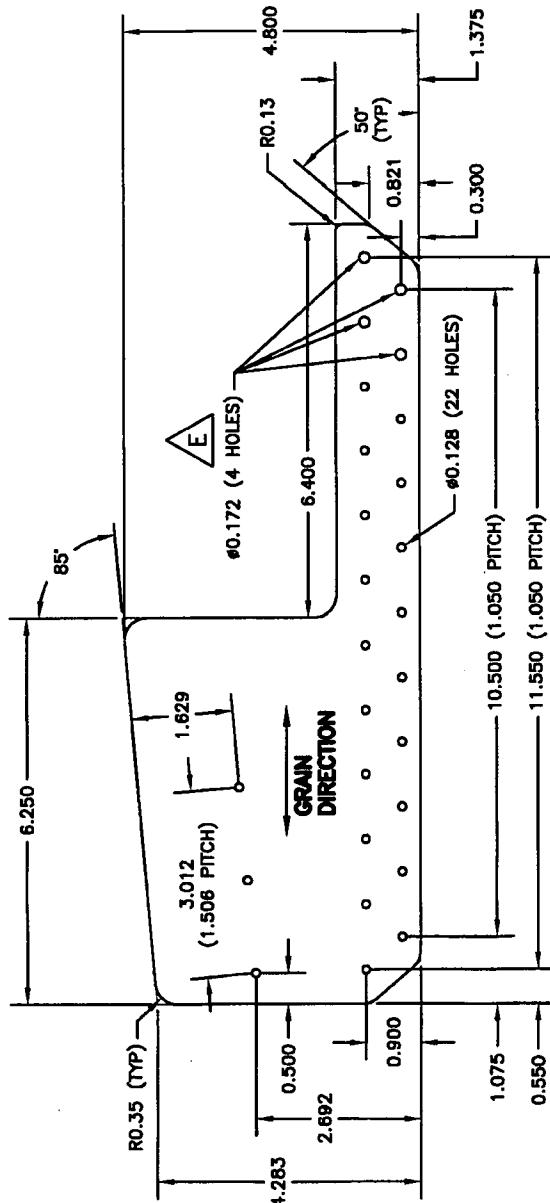
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**DART**

DESIGN RF	DRAWN BY CE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED H	DRAWING NO. D2174	REV. E SHEET 2 OF 2
DATE 06.09.25		TITLE WEB	SCALE 1:3

**RELEASED**  
06.10.3

D2174-1

NOTES:  
1) MATERIAL: 2024-T3 SHEET (QQ-A-200/4) 0.063 THICK (REF. DART SPEC. M2024T3S.063)  
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) BREAK ALL SHARP EDGES 0.005 TO 0.010  
5) ALL DIMENSION ARE IN INCHES  
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48349

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